

**Claims:**

1. Method for the production of a lighting element comprising at least one luminescent diode and an inserted light-guiding body, which is arranged in front of said luminescent diode in the direction of the exit of the main light, wherein the respective luminescent diodes are connected to the inserted light-guiding body by an injection molding process with transparent plastic, said method being characterized in that,
  - at least 50% of the surface (12) of the light-emitting diodes is covered by the injected material (30) during injection molding, and
  - that the maximum wall thickness of the injected layer (30) does not exceed three-times the minimum wall-thickness of said layer (30).
2. Method according to claim 1, characterized in that the lower edge (32) of the injected layer (30) engaging radially around the surface (12) of the light-emitting diode ends below a plane, which runs normal to the centerline (7) of the luminescent diode (11) and through the center of gravity of the light-emitting chip (6) of this luminescent diode (11).
3. Method according to claim 1, characterized in that the luminescent diode (11) and the inserted light-guiding body (21) are located on a common centerline (7), wherein the centerline (7) runs through the center of

gravity of the light-emitting chip (6) of the luminescent diode (11).

4. Method according to claim 1, characterized in that the  
5 lighting element (70) is made of several individual  
lighting elements (10) arranged adjoining to one  
another.

10 5. Method according to claim 4, characterized in that the  
centerlines (7) of the individual lighting elements  
(10) are arranged parallel to one another or intersect  
in an at least partially fan-like manner at one or  
more points located behind the lighting element (70)  
or intersect at a short distance.

15 6. Method according to claim 1, characterized in that the  
inserted light-guiding body (21) comprises a concave  
recess (25) towards the diode (11).

20 7. Method according to claim 1, characterized in that a  
light lens (40) for designing a main light exit  
surface (41) is molded into the combination of the  
diode (11), the inserted light-guiding body (21) and  
the injected layer (30) in an additional injection  
25 molding step.

8. Method according to claim 7, characterized in that the  
light lens (40) is a diffusing screen.

30 9. Method according to claim 1 and 8, characterized in  
that the inserted light-guiding body (21) has a

different color than that of the diffusing screen (40).

10. 10. Method according to claim 1, characterized in that at least one substance is admixed to the material of at least one component (11, 21, 30, 40), wherein said substance emits a light of another wavelength when excited by the light emitted from the chip (6).
11. 11. Method according to claim 1, characterized in that the luminescent diodes (11) are fixed on a circuit board before the coating by means of injection molding.